

**PATENT
APPLICATION**

Title: **Stamping process and tools, applications especially to stamping of benches, and stamped articles, especially seating benches obtained by such process and tools.**

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Applicant(s): **SERINOX S.A.**

ABSTRACT

A stamping process such as that applied for stamping a metal sheet T between a bottom die 10 and a punching die 4 clamped between a front blank holder (AV) and rear blank holder (AR), characterized in that the AR blank holder 20 widens toward the rear relative to the dimensions of the prior art and has on the end adjacent to the punching die 4 (that is, the front end AV of the rear AR blank holder) a convex shape, that is, a shape which permits progressive deformation of the sheet in depth, and deformation over a greater blank holder length, in place of the right angle of prior-art blank holders.

The possibility is provided of varying the spacing E by means of a set of shims.

There are numerous applications, including vehicle seating benches with 2, 6, 8, or more seats.

Figure 8